

CLAIMS

1. A method for packaging disc-shaped digital record carriers in a corresponding folding package (10), said package (10) including a blank (11) and a tray (12) fastened to a corresponding section (13) of said blank (11,111), said method being characterized in that it includes a cyclical repetition of the following operation steps:
- 10- Feeding a tray (12) along a first path (A) of a line for packaging said discs (1), said tray having in its first surface (14) a housing (15) for receiving a disc (1);
- Feeding a disc (1) along a second path (B) of said packaging line, converging toward said first path (A) at a convergence point, and moving said disc (1) until it is aligned with the housing (15) of the tray (12);
- introducing said disc (1) in said housing (15);
- feeding said blank (11) along a third path (C) of said packaging line, said third path (C) intersecting said first path (A) at an assembling station of said package (10), downstream of the above mentioned convergence point between the first path (A) and the second path (B);
- 25- placing said tray (12) and said section (13) in mutual alignment, after introduction of the disc (1) into said tray (12);
- assembling, in said assembling station, said tray (12) to an inner surface (13a) of said section (13), with
- 30 interposition of a layer of gluing material, to fasten

said tray (12) to said section (13) and to obtain said package (10);

conveying said package (10) toward a station, where it is folded to the closed conformation.

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2. A method as claimed in claim 1, characterized in that said gluing material is applied to a second surface (24) of each of said trays (12) facing said inner surface (13a) of the section (13), before introduction of the disc (1) into the tray (12).

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3. A method as claimed in claim 1, characterized in that said gluing material is applied to a second surface (24) of said tray (12) facing said inner surface (13a) of the section (13), after the introduction of the disc (1) into the tray (12) and before assembling the tray to the blank.

4. A method as claimed in claim 1, characterized in that said gluing material is applied to said inner surface (13a) of the section (13).

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5. A method for packaging disc-shaped digital record carriers in a corresponding folding package (110), said package (110) including a blank (111) and a predetermined number of trays (112), each of said tray being fastened to a corresponding section (113) of said blank (111), said method being characterized in that it includes a cyclical repetition of the following operation steps:

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- feeding a predetermined number of trays (112), set side by side, along a first path (A) of a line for packaging said discs (1), each of said tray having a housing (115) in a first surface (114) for receiving a disc (1);
5 disc (1);
- feeding as many discs (1) as there are trays (112) the first path of the packaging line, along a second path (B) of said packaging line, converging toward said first path (A) at a convergence point, and placing each disc
10 (1) in alignment with a housing (115) of a corresponding tray (112);
- introducing each of said discs (1) in a corresponding housing (115);
- feeding said blank (111) along a third path (C) of
15 said packaging line, said third path (C) intersecting said first path (A) at an assembling station of said package (10), downstream of the above mentioned convergence point between the first path (A) and the second path (B);
- 20- setting each of said trays (112) in alignment with a corresponding section (113), after the introduction of the discs (1) into said trays (112);
- assembling, in said assembling station, each of said trays (112) to the inner surface (113a) of the
25 corresponding sections (113), with interposition of a layer of gluing material, in order to fasten each tray (112) to a corresponding section (113) and to obtain said package (10);
- conveying said package (10) toward a station, where
30 it is folded to the closed conformation.

6. A method as claimed in claim 5, characterized in that said gluing material is applied to a second surface (124) of each of said trays (112) facing a corresponding inner surface (113a) of the corresponding section (113), before
5 the introduction of the disc (1) into the corresponding tray (112).

7. A method as claimed in claim 5, characterized in that said gluing material is applied to a second surface (124)
10 of each of said trays (112) facing an inner surface (113a) of a corresponding section (113), after the introduction of the disc (1) into the corresponding tray (112) and before assembling the tray to the blank.

15 8. A method as claimed in claim 5, characterized in that said gluing material is applied to said inner surface (113a) of each section (113).

9. A method as claimed in claim 5, characterized in that,
20 after the discs (1) have been introduced into the corresponding trays (112), said trays (112) are spaced apart sidewise, in order to bring them to a position matching the correct distance on said blank (111), as a function of the selected modes of the subsequent folding
25 of the package (110).